



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4297-1
Job Sheet 176637



Part No: D4297-1

Job Qty: 10 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 11-01-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		5/14/18	0.00	0.00	Start Up Waterjet		ac 18/04/27
120	Waterjet	10 pcs		5/14/18	0.00	2.33	Waterjet1		DIAS 18/04/27
130	CNC Vertical Machining	10 pcs		5/14/18	0.00	14.74	HAAS1-4		52 18/05/10
140	QC	10 pcs		5/14/18	0.00	0.00	QC2 Machining-2		89 18/05/10
150	QC	10 pcs		5/14/18	0.00	0.00	QC8 Machining-2		72 18/05/10
151	Packaging	10 pcs		5/14/18	0.00	0.00	Packaging3		MAY 16 2018 6
190	QC21-SA	10 Ea		5/14/18	0.00	0.00	QC21		21 18/05/10

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA028 and Dwg DWG

REV: _____ FOLIO REV: _____ 3-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	37 sf (3.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	37	1,675	0

Part Specifications

Specifications could not be found.

Plex 4/26/18 1:51 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS
		Water Jet ☐ Engineering ☐ g. Coord. ☐ Quality ☐ Packaging ☐ Other ☐ Supplier ☐
		MRB (QS1042) Approval
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Description Work

Dart Aerospace Ltd.
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CANADA
TEL: 1 813 832-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 04/27/18

Container No: S066157
Part: D4297-1
Job No: 176637
Serial No/Batch: S066157
Revision: _____
Inspector: _____

Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

DART AEROSPACE LTD		Work Order: 176637
Description: Bearpaw		Part Number: D4297-1
Inspection Dwg: D4297 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063x45°	✓		Ver	
D 0.25 x 45°	+/-0.030	0.25x45°	✓		Ver	
E R0.250	+/-0.030	R.0.25	✓		R.G.	
G 0.63	+/-0.030	0.630	✓		Ver	
H 0.38	+0.030/-0.010	0.38	✓		Ver	
I 0.950	+/-0.030	0.950	✓		Ver	
J 19.000	+/-0.030	19.000	✓		TAPE	
M Ø0.260	+0.005/-0.000	Ø0.260	✓		G.P	
N Ø0.93	+/-0.030	Ø0.930	✓		Ver	
O 0.30	+0.030/-0.000	0.315	✓		D.G.	
P 23.750	+/-0.030	23.750	✓		TAPE	
S 2.000	+/-0.030	2.020	✓		Ver	
T 0.20	+/-0.030	0.20	✓		D.G.	
U 11.000	+/-0.010	11.000	✓		TAPE	

Measured by: DAS 52 9-89	Audited by: [Signature]	Preliminary Approval:
Date: 18/05/10	Date: 18/05/15	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.20	New Issue P/O D350-578-013	KJ	
B	12.02.01	Dwg Rev updated	KJ	
C	12.07.31	Dwg Rev updated	KJ	
D	15.02.09	Dimensions revised	KJ	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					